

Work Order ID 57706

April 14, 2010 10:08:23 AM

Step 26/04 *PLATES*

Page 1

Item ID: D2563

Accept



Setup Start



Revision ID:

Item Name: Step Weldment Assembly

Stop



Start Date: 14/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 22/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-4-14*

Tooling:

Date:

Run Start



QC: ..

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2563

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563

2-Deburr ends

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg D2563 using DT 8343

4- Grind

Red: 3111311 & 114242

10.04.21

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

8 10.04.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

S 10/04/10



QC

Memo

0.00

(18)

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

pk 10-04-21



HandFinish

Memo

0.00

(8)

Hand Finishing

140

QC3- Inspect Part Finish

0.00

SAD



QC

Memo

0.00

10-04-21

(8)

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Large Fab

Weld per dwg A/R Aluminum rod Batch: *M11131* 0.00
Large Fab

Memo

0.00

8 *8*

Large Fab

1-Inspect for foreign object per QSI 024

2-Weld Remainig End cap as per Dwg D2563 using DT 8343

10-04-22

3-Grind

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

8 *PD 10.04.22*

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

*8 10.04.22**8*

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

11/14/207

Memo

0.00

Touch up Alodine then 10/04/22 (x8)
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

12:00pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

12:30pm

=> 10/04/22 X8

190



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch

0.00

11/3545

Memo

0.00

10-4-23

200



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10-4-23 (80) 50

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: _____

0.00

PP

57703

10-4-23

SL 8X



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

LA 10.04.23

MF 10-4-23

W/O:		WORK ORDER CHANGES					
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Picklist Print

April 14, 2010 10:08:28 AM

Page 1

Work Order ID: 57706

Parent Item: D2563

Parent Item Name: Step Weldment Assembly


Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2244-116  Step Extrusion		Manufactured	No			100	Each	9.8421	8.0000		10.04.19	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

9.8421

38023

9.8421

D2561

Manufactured

No

100

Each

21.0000

16.0000



Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MEZZ

21

53616

21

D2564

Manufactured

No

100

Each

31.0000

16.0000



Mounting Angle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MEZZ

31

47966

11

56292

20

D2673-34

Manufactured

No

100

Each

0.0000

4.0000



End Plate

10.04.20 (8) 3.57527

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

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Parent Item: D2563



Parent Item Name: Step Weldment Assembly



Start Date: 14/04/2010

Required Date: 22/04/2010

Comments: IPP Rev:G 02.07.31 Re-format Location RF

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2673-34  End Plate		Manufactured	No			150	Each	0.0000	4.0000 			

10.04.22 (8) 857527

April 14, 2010 10:08:28 AM

Shop Packet Print

Page 2

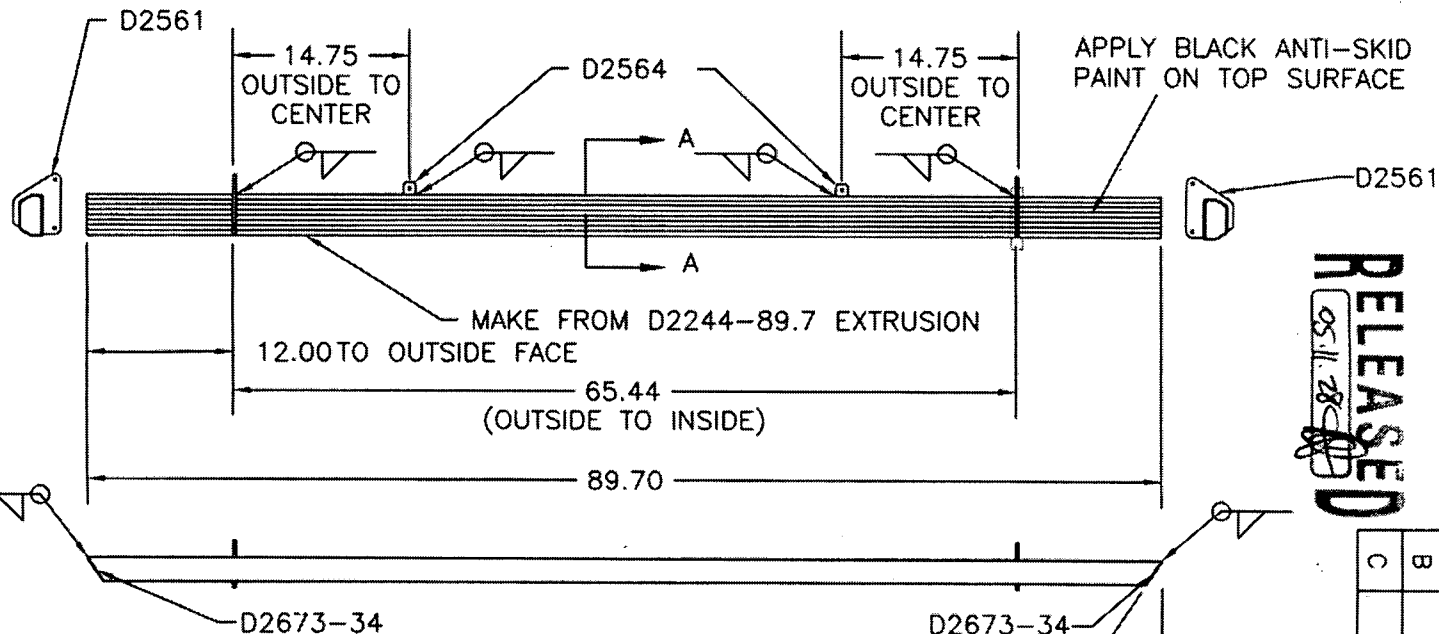
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D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
BW	44	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
		D2563	
DATE	TITLE	SCALE	
05.11.14	STEP WELDMENT ASSEMBLY	1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

OP COPY
RETURN TO
ENGINEERING
ROLLED
TO AMEND
OUT NOTE
WORK ORDER
No. 57706
2810-4-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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